

# Work Order ID 63662

Tuesday, November 09, 2010 8:22:12 AM

Page 1

Item ID: D3915-041

Accept

Revision ID:

Item Name: Light Lid Assembly, Long Basket

Start Date: 11/9/2010 Start Qty: 1.00

Required Date: 11/16/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: mf

Date: 10-11-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3915	C

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 112860 0.00  
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D3915

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

PL 10-11-10

1 Q BE 10/11/11

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

✓ Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

\*\*\*ENSURE TO RINSE CAREFULLY ACID AND ALODINE\*\*\*

140

Weld per dwg A/R Aluminum rod Batch: \_\_\_\_\_

0.00



Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

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Required Date: 11/16/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_




Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				1	0	BE 10/11/11	
155  QC Quality Control	QC6- Inspect dimensions to drawing  Memo ***inspect fit of lid with base***	0.00  0.00						Pl 10.11.15	(AC21 10.11.22 TEST. to step. 155)
157  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo 1- realodine corners ***do not acid etch***	0.00  0.00				1		10-11-29	



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Item ID:	D3915-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Light Lid Assembly, Long Basket					
Start Date:	11/9/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	11/16/2010	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo 1- touch up corner with alodine only 2- Plug holes prior to <i>M115951</i> 1ST COAT: START TIME: <i>1:05</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>1:35</i> ***** 2nd coat if necessary ***** 2ND COAT: <i>M115951</i> START TIME: <i>2:55</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>3:25</i>	0.00  0.00				<i>1</i>		<i>BR 10-11-29</i>	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>=1</i>		<i>10/11/29</i>	<i>1</i>

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Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

190



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

200



Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

0.00

EP 10/11/30 ①

- shipping for testing  
only. inspectors  
Solutions to RVC - test. AB.

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Revision ID:

Stop



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Start Date: 11/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CMF  
10-11-30

# Picklist Print

Tuesday, November 09, 2010 8:22:12 AM

Work Order ID: 63662



Parent Item: D3915-041



Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1  Dart Logo label		Manufactured	No			180	Each	0.0000	1	1		11/11/30	
D2957  Mounting Plate		Manufactured	No			100	Each	15.0000	4	4		10-11-10	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			15						
				57697			1						
				58302			12						
				58593			2						
D3915-1  Rib		Manufactured	No			100	Each	2.0000	2	2		10-11-10	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			2						
				58379			2						

① ①  
② ①  
B63663 → ②

# Picklist Print

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Work Order ID: 63662

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

D4016-5

Manufactured No

100

Each

15.0000

3

3



Hinge Half, Light Lid

Location

Loc Qty

Loc Code

ENG

2

56075

2

ST116

10

58304

10

WA

3

58592

3

D4019-3

Manufactured No

100

Each

7.0000

3

3



Rib

Location

Loc Qty

Loc Code

WA

7

58386

1

59745

6

D4029-041

Manufactured No

180

Each

6.0000

1

1



Webbing (Long Basket)

Location

Loc Qty

Loc Code

st503

6

56963

1

58109

5

D4035-045

Manufactured No

100

Each

2.0000

1

1



Lid Rib Assembly, Fwd (Light)

Location

Loc Qty

Loc Code

WA

2

59733

2

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Shop Packet Print

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# Picklist Print

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Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

D4035-047 Manufactured No

100 Each

2.0000

1

1



Lid Rib Assembly, Aft (Light)

Location

Loc Qty

Loc Code

WA

2

59734

2



B63669 → ①

D4056-1 Manufactured No

100 Each

12.0000

1

1



Label Plate

Location

Loc Qty

Loc Code

WA

12

58308

9

58583

1

59750

2



①

MS20600-AD4W3 Purchased No

180 Each

1,489.000

34

34



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1489

107939

754

111636

735



4510/11/30

34

# Picklist Print

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Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN416J

Purchased

No

180

Each

502.0000

34

34



Washer

*Handwritten signature*  
*11/30*

Location

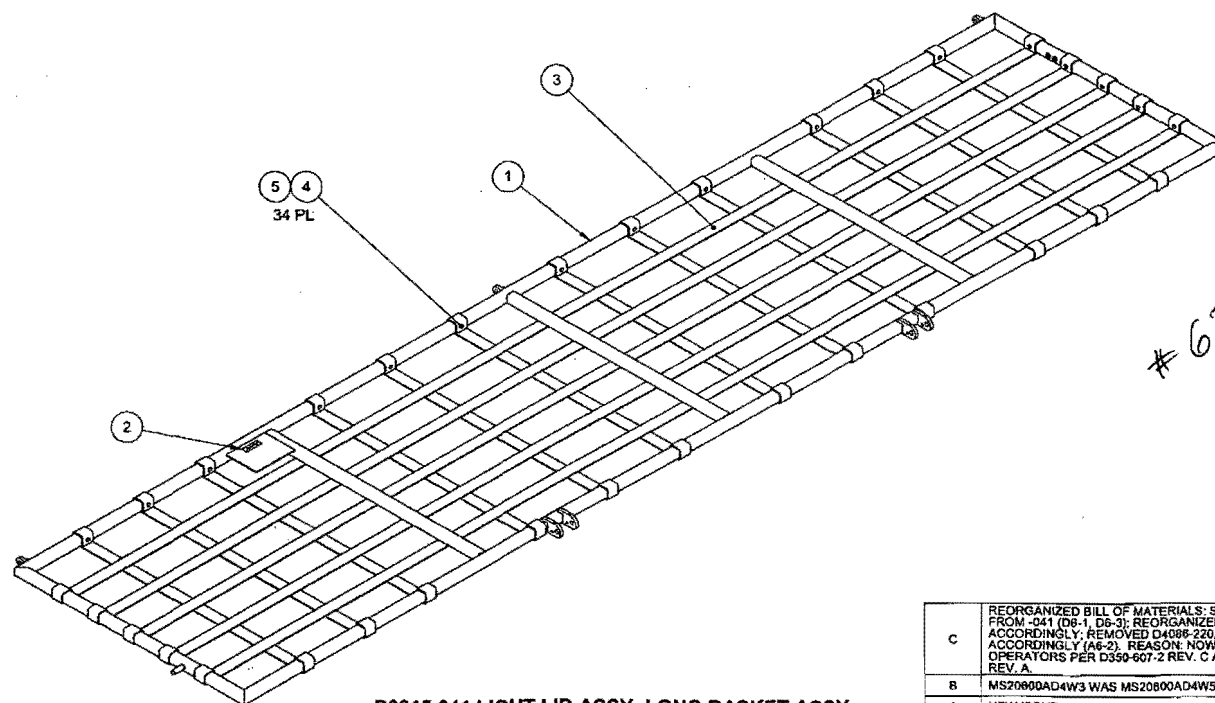
Loc Qty

Loc Code

ST	4
13910	4
ST275	102
114340	102
ST298	396
114348	52
114597	344

*34*

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER



**D3915-041 LIGHT LID ASSY, LONG BASKET ASSY**

**NOTES:**

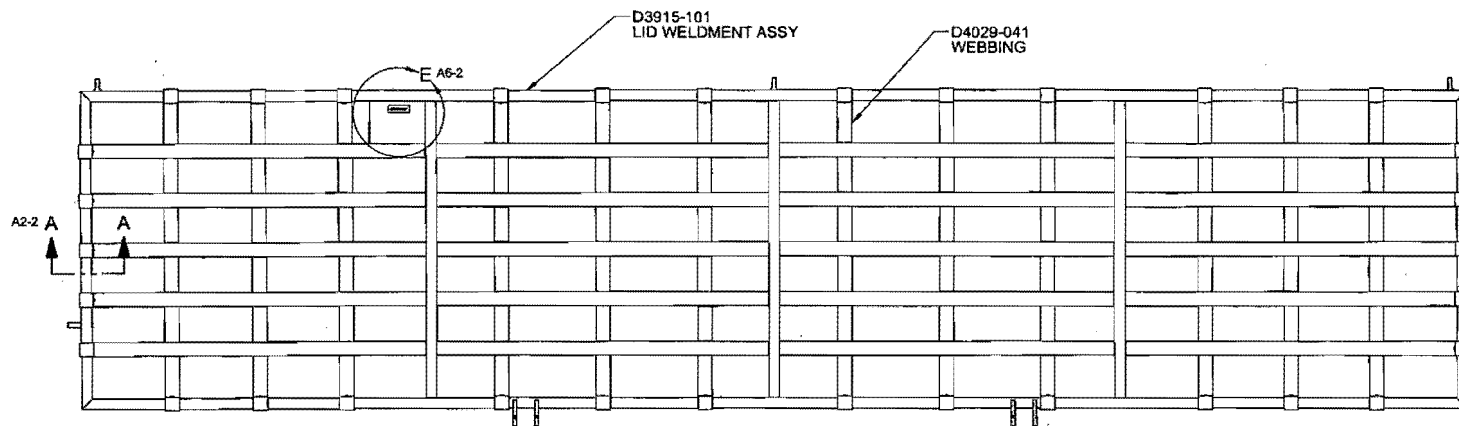
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C		REORGANIZED BILL OF MATERIALS, SEPARATED -101 FROM -041 (DB-1, DB-3); REORGANIZED VIEWS ON-SHT 3 ACCORDINGLY; REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY; (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D390-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
B		MS20600AD4W3 WAS MS20800AD4W5: BOM & (B1-2)		JPH	10.04.06
A		NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION			BY	DATE
DESIGN	ALS			DART AEROSPACE LTD	
DRAWN	S			HAWKESBURY, ONTARIO, CANADA	
CHECKED	S			DRAWING NO.	REV. C
MFG. APPR.	S			D3915	SHEET 1 OF 4
APPROVED	M			TITLE	SCALE
DE APPR.	M			LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05			<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR EQUIVALENT TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

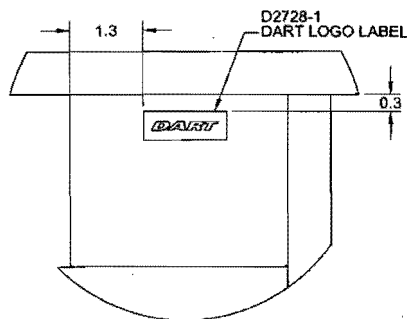
**RELEASED**  
10.08.12 UP  
ECN 10-596

#63662

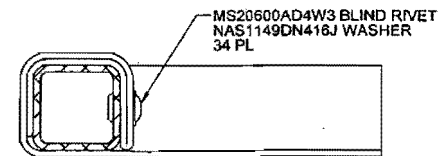
#63662



**D3915-041 LIGHT LID ASSY. LONG BASKET**



**VIEW E D6-2**

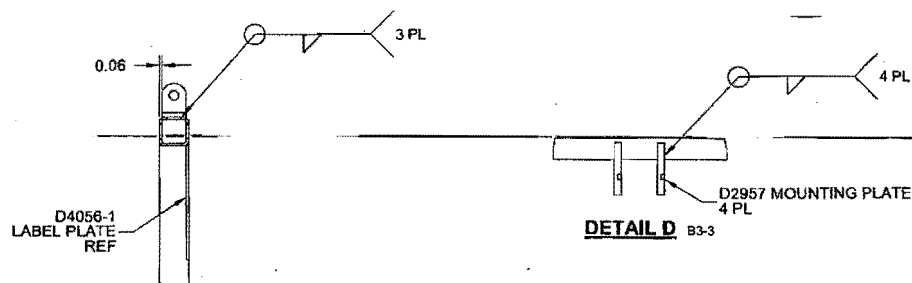


**SECTION A-A C8-2**

**RELEASED**  
10.08.17

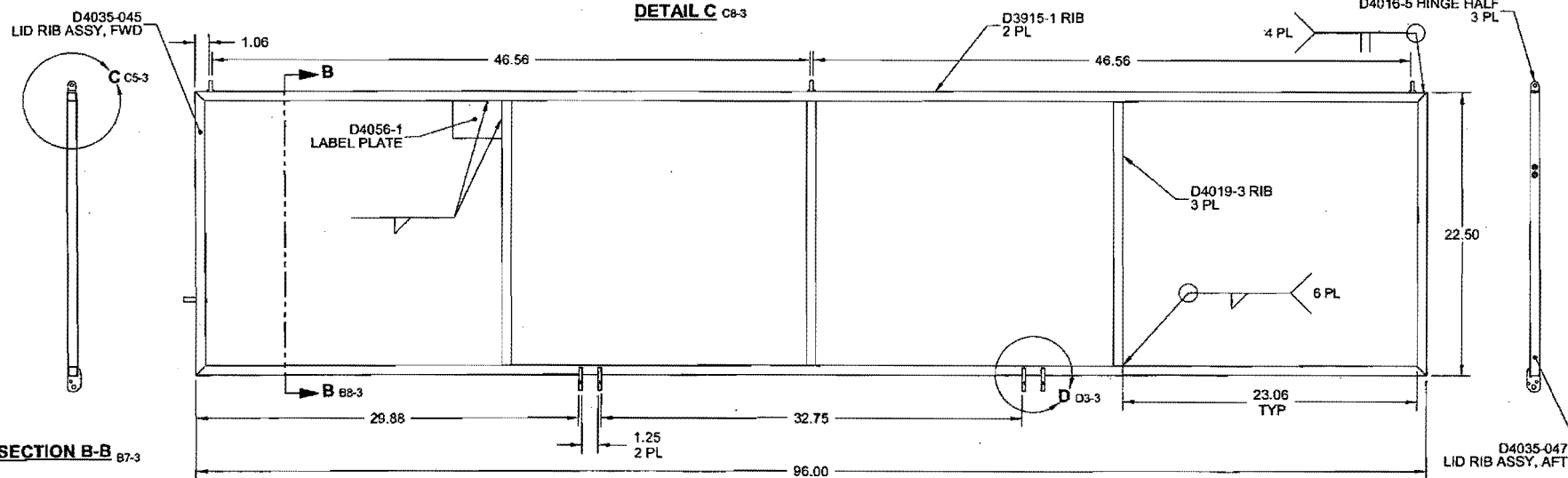
DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Sc	DRAWING NO. <b>D3915</b>	REV. C
MFG. APPR.	Sc		SHEET 2 OF 4
APPROVED	Sc	TITLE	SCALE
DE APPR.	Sc	<b>LIGHT LID ASSY-LONG BASKET NTS</b>	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



#63662

DETAIL C C8-3



D3915-101 BASKET LID WELDMENT ASSY

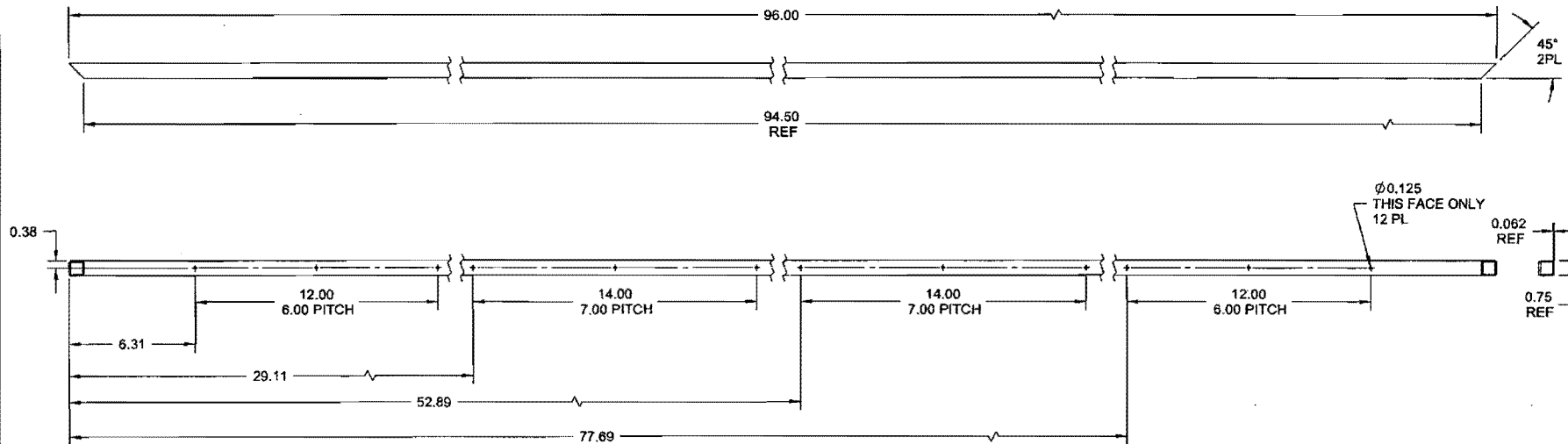
RELEASED  
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	4.15	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3915	REV. C
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#63662



**D3915-1 RIB**

RELEASED  
(10-09-12 CP)

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6S0.750W.062
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.49 lbs

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3915	REV. C
CHECKED		SHEET 4 OF 4	
MFG. APPR.		TITLE	SCALE
APPROVED		LIGHT LID ASSY-LONG BASKET NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ADDED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		